



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

647.1404

Job Sheet 159640



Part No: 647.1404

Job Qty: 1 ea

Part Name: Upper Cutter Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/30/17

Job Tracking No:

Due Date: 11/15/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV C IPP REV:A 16.03.28 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Part/Part Name	Part Note	Serial No	Quantity	Location
647.1404 Upper Cutter Assembly	DWG REV C IPP REV:A 16.03.28 NEW ISSUE DD VERF: JLM		0.000	
646.9703 Cutter Sub Assembly	DWG REV D2 IPP REV:A NEW ISSUE 16-03-07 JLM VERIF			
647.1513 Upper Deflector	DWG REV D IPP Rev.A New issue JFS 16/03/09 Verified			
MS21042L08 Nut				
MS27039-08-19 Screw				
NAS1149FN832P Washer				

Status: Stock

Part: **647.1404 B159640**

Created: 9/30/17 10:53 AM DART.MICHAUD-
FEBRILLE.VICTORIA



Serial No: **S000016**

Printed By: Goldston, Justin 10/2/17 10:44 AM

Job Routing

Op No	Operation	Qty	Due Date	Standard		Workcenter/Supplier	
				Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea	11/14/17	0.00	0.00	Start up container	MAY 10 2018
130	QC	1 pcs	11/15/17	0.00	0.00	QC5	MAY 29 2018
140	Packaging	1 pcs	11/15/17	0.00	0.00	Packaging3	MAY 30 2018
150	QC21-SA	1 Ea	11/15/17	0.00	0.00	QC21	MAY 30 2018

Part Op 140 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***
Descriptions: Primer 138408

Job BOM

Part / Item	Component Name	Quantity	Operation	Special Comments
646.9703	Cutter Sub Assembly	1 Ea (1 ea)	90-Start up Operation	
647.1513	Upper Deflector	1 Ea (1 ea)	90-Start up Operation	
MS21042L08	Nut	3 Ea (3 ea)	90-Start up Operation	
MS27039-08-19	Screw	3 Ea (3 ea)	90-Start up Operation	
NAS1149FN832P	Washer	6 Ea (6 ea)	90-Start up Operation	
647.1404 B159640		1 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	646.9703	1	0	0	0
	647.1404 B159640	1	1	0	0
	647.1513	1	0	0	0
	MS21042L08	3	0	0	0



Container No: S075438



Part: 647.1404

Job No: 159640

Serial No/Batch: S075438

Revision: D

Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 05/29/18

RECEIVED YAM
100
100

MS27039-08-19
NAS1149FN832P

3
6

0
0

0
0

0
0

Part Specifications

Specifications could not be found.

Plex 10/1/17 2:01 PM Dart.Baker.Diane

Work Order Summary

Thursday, September 28, 2017 8:21:15 AM

Page 1 of 2

Criteria : Work Order ID: 159640 Item ID: 647.1404 Product Family MACHINING
 Work Order Start Dates 4/18/2017 to 4/18/2017 11:59:59 PM Work Order Required Dates 5/26/2017 to 5/26/2017 11:59:59 PM
 Reference: RMA RA112439
 Work Order Status Released

Work Order ID 159640 Required Qty 1.0000 Status Code Released
 Item ID 647.1404 Accepted Qty 0.0000 Scrap Qty 0.0000
 Item Name Upper Cutter Assembly
 Current Acct Value \$672.786

Start Date 4/18/2017 Required Date 5/26/2017 Completed Date

Rework ** Actual ** ** Acct. Value ** ** Variance ** ** Variance % **

Direct Costs	Total	Each	Each	Each	Each
Material	\$49.174	\$0.000	\$49.174	\$49.174	100.00%
Labor	\$130.339	\$0.000	\$101.332	\$101.332	100.00%
Outplant	\$18.770	\$0.000	\$18.770	\$18.770	100.00%
Variable Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Fixed Burden	\$303.215	\$0.000	\$226.047	\$226.047	100.00%
Material Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
** Total **	\$501.497	\$0.000	\$395.323	\$395.323	

Item ID/Item Name	Required Qty	Issue Code	Issue Date	Issued Qty	Cost Amount
647.1404 Upper Cutter Assembly	1.0000		4/18/2017	1.0000	\$395.323
Total Matl Amts:					\$395.323

Work Center HandFinish

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
SHEL02												
8/17/2017												
100			0.00	0.00	0.23	0.12	2.00	\$0.000	\$2.520	\$6.291	\$0.000	\$8.811
Total:			0.00	0.00	0.23	0.12	2.00	\$0.000	\$2.520	\$6.291	\$0.000	\$8.811

Work Center Small Fab

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
BOUC02												
5/23/2017												
110			0.00	0.00	0.53	0.53	1.00	\$0.000	\$11.007	\$29.454	\$0.000	\$40.462
5/24/2017												
110			0.00	0.00	0.75	0.75	1.00	\$0.000	\$15.480	\$41.423	\$0.000	\$56.903

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Work Order Summary

Page 1 of 2

Total:	0.00	0.00	1.28	1.28	2.00	\$0.000	\$26.487	\$70.877	\$0.000	\$97.364
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Work Order ID 159640

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159640

Page 1

Item ID: 647.1404

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Upper Cutter Assembly

Start Date: ~~4/18/2017~~ Start Qty: 1.00***1***

Cust Item ID:

Required Date: 5/26/2017 Req'd Qty: 1.00

1

Customer: CETEC01

Reference: RMA RA112439

Approvals: Process Plan: Date: **MAY 18 2017**

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
647.1400	C								

100

0.00

100

HandFinish

Hand Finishing

Memo

0.00

1-Original Batch # of 647.1404: B **146128**

2-Strip paint

110

0.00

110

Small Fab

Small Fab

Memo

0.00

1-Disassemble, remove old loctite. Scrap old hardware. 

2-Assemble as per dwg. using all new hardware and apply loctite 598 on all faying surfaces per note 2.

A/R RTV Loctite: _____

EXP. Date: _____

  

DAS
36
089

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☒

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
When removing (stripping) paint primer was remove too				prime per QSI.				PD 17-0526	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐								
Misidentified	☐	Past Due	☐	OTHER : _____							

Work Order ID 159640

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159640

Page 2

Item ID: 647.1404**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Stop *NS2*****Item Name:** Upper Cutter Assembly**Start Date:** 4/18/2017 **Start Qty:** 1.00 ***1*****Cust Item ID:****Required Date:** 5/26/2017 **Req'd Qty:** 1.00 ***1*****Customer:** CETEC01**Reference:** RMA RA112439**Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start *NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				_____	_____	_____	_____
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV.***	0.00 0.00				_____	_____	_____	_____
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				_____	_____	_____	_____

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

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Page 1

Work Order ID: 159640

159640

Parent Item: 647.1404

647 1404

Parent Item Name: Upper Cutter Assembly

Start Date: 4/18/2017

Required Date: 5/26/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 16.03.28 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

647.1404

Manufactured

No

Each

2.0000

647 1404

Upper Cutter Assembly

146728

**



MAY 18 2017

Location

Loc Qty

Loc Code

CCK048

2

153186

2

647.1403 (1) 146920

647.1313 (1) 146730

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Inspection Sheet Complete RA112439

Customer QA Ref # SO128433

Part Number	Batch / Serial #	Quantity	Part Complete	Rev/CHG Current	New Paperwork	New Labels	Disposition	Work order #	Work order Instructions
647.1404	B146728	1	☐ Yes	☐ Yes	☐ Yes	☐ Yes	DAMAGED/REPAIRABLE	159640	Part return from customer painted, part was install but not flown. 647.1404 will need to be disassemble, strip and reassemble with new hardware I.D. at Rev B. and stock
0		0	☐ Yes	☐ Yes	☐ Yes	☐ Yes			
0		0	☐ Yes	☐ Yes	☐ Yes	☐ Yes			
0		0	☐ Yes	☐ Yes	☐ Yes	☐ Yes			
0		0	☐ Yes	☐ Yes	☐ Yes	☐ Yes			
0		0	☐ Yes	☐ Yes	☐ Yes	☐ Yes			

QC Approval: P.D. _____

Date: 15-Apr-17 _____

646.9703 B146990 Rev D2
still good @ Rev D

647.1513 B146730 Rev C
good.

EUROTEC VFS, LLC

1040 OCL PARKWAY, EUDORA, KS 66025



Crtl#: 28504

CrtlID: 1

PN: 647.1404
DESC: UPPER, CABLE CUTTER ASSY

MFG CODE: DART PO: 4523
COND: AR REC.DATE: 1/19/2017
LOCATION: W1FG
RECEIVER #: 2168701192017BAT
EXP DATE: 0
CERT SOURCE: APPROVED SOURCE
REMARK:
Certified By: EC135/SN1131



Qty: 1

Notes: UNIT DID NOT CONFORM TO
A/C UPON INSTALL - REMOVED
AND RETURNED FOR CORRECT
UPPLE CABLE CUTTER PN 647.7401

☐ REPAIRABLE	☒ TRACEABILITY
Notes: Damaged SV from MK 501123 (661.5) not checked out from the aircraft. requires inspection.	
Signature: <i>[Signature]</i>	
Stamp: Warning this tag must remain with the part at all times for traceability reasons. This is not an airworthiness tag (requires inspection)	12086

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